

Work Order ID 78010

December-28-11 1:26:56 PM

78010

Page 1

Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly Aft, Low Gear
 Start Date: 23/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 01/02/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/12/28 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3805	B

100 0.00

100

Large Fab

Large Fab

Memo

0.00

1-weld D3806-5 to D3805-5 together as per dwg D3805

304 S.S. Welding Rod

BATCH #: M118367

2-Transfer drill holes in bar

2059B → M120645

(10) MAL 12/02/17

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

110

QC

Quality Control

Memo

0.00

12.02.17 Pto →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3805-045 PAR #: _____ Fault Category: Large FAIB NCR: Yes No DQA: [Signature] Date: 12/2/27
 Resolution: Acceptable Disposition: Acceptable QA: N/C Closed: [Signature] Date: 12/2/27

NCR: <u>12-1226</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>12/02/17</u>	<u>#100</u>	After welding welder notices that he has placed the Bar (D3806-5) too far Prod. instead of	<u>CP</u> <u>12.02.17</u> <u>B7042</u>	<u>Acceptable</u>	<u>n/a</u>	<u>S</u> <u>12/02/17</u>	<u>CP</u> <u>12.02.17</u> <u>B7042</u>	<u>S</u> <u>12/02/17</u>
		having the carbide welder end flus (on two ends) it has the Stariles mat. R.L. 10A when placing Bar Before welder	<u>CP</u> <u>12.02.17</u>	<u>[Wavy Line]</u>			<u>CP</u> <u>12.02.17</u>	<u>S</u> <u>12/02/17</u>

NOTE: Date & initial all entries

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Item ID: D3805-045 Accept ***N900040100*** Setup Start ***NS1***
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 Required Date: 01/02/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 12:30								
	OVEN TEMPERATURE: 320°F								
	FINISH TIME: 1:00								

140	QC3- Inspect Part Finish	0.00							
140									
QC	Memo	0.00							
Quality Control									

M 118489

10X12 M-12/22/17

M 12. 02. 17 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78010

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Page 3

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 Revision ID: Stop ***NS2***
 Item Name: Wearplate Assembly Aft, Low Gear
 Start Date: 23/12/2011 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 01/02/2012 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150									
Small Fab	Memo	0.00							
Small Fab	1- Bond D3807-5 gasket to inner surface of wearplate using a thin layer of 3m 1300/1300L scotch grip adhesive as per dwg BATCH: <u>m/20159</u>								
160	QC5- Inspect part completeness to step on W/O	0.00							
160									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location: <u>1P-1</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									

X10 φ M 12/02/21
 counted a measure

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Work Order ID 78010

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Page 4

Item ID: D3805-045

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 23/12/2011 Start Qty: 8.00

8

Cust Item ID:

Required Date: 01/02/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/2/21

MR

12-02-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-28-11 1:26:59 PM

Page 1

Work Order ID: 78010

78010

Parent Item: D3805-045

D3805-045

Parent Item Name: Wearplate Assembly Aft, Low Gear

Start Date: 23/12/2011

Required Date: 01/02/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 08-12-01 new issue EC verified by:DD IPP Rev:B 09-03-04 rev.a as per dwg DD verified by:EC IPP Rev:C 11.10.04 rev.b as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3805-5		Manufactured	No			100	Each	35.0000	1	8			
D3805-5									**				
Plate													

78128 x 10

Location	Loc Qty	Loc Code
WA025	33	
76738	33	
WA030	2	
75676	2	

(10) MAL 12/02/17

D3806-5		Manufactured	No			100	Each	54.0000	1	8			
D3806-5									**				
Bar													

78130 x 10

Location	Loc Qty	Loc Code
WA	50	
74889	20	
74890	30	
WA030	4	
46781	2	
75941	2	

EL 12-2-16

D3807-5		Manufactured	No			150	Each	55.0000	1	8			
D3807-5									**				
Gasket													

Location	Loc Qty	Loc Code
GA	55	
74944	1	
76742	54	

B78132 x 10 Ae 12/02/17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

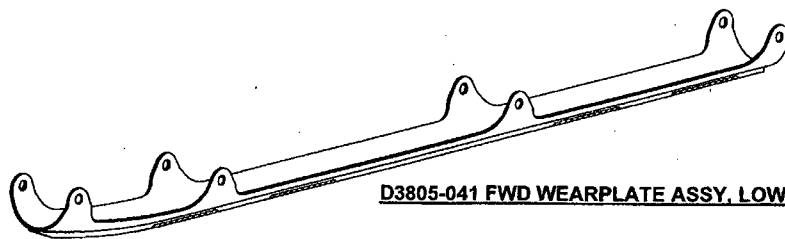
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

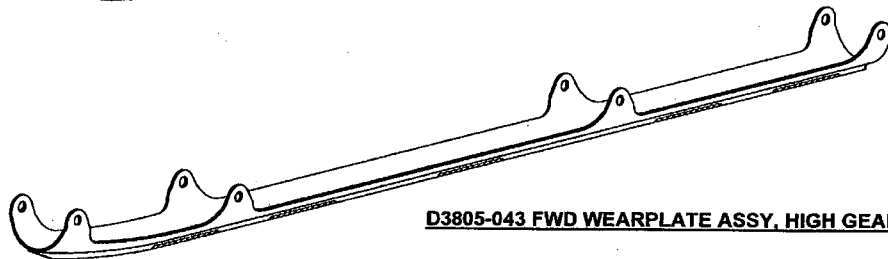
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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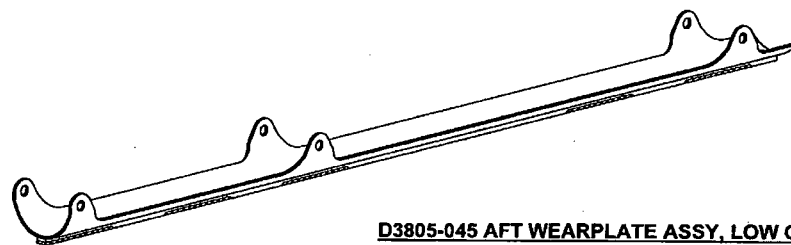
8 7 6 5 4 3 2 1



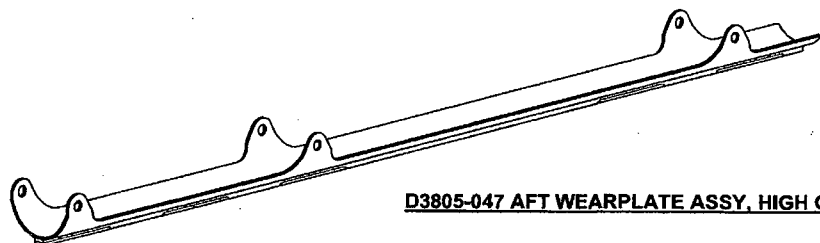
D3805-041 FWD WEARPLATE ASSY, LOW GEAR



D3805-043 FWD WEARPLATE ASSY, HIGH GEAR



D3805-045 AFT WEARPLATE ASSY, LOW GEAR



D3805-047 AFT WEARPLATE ASSY, HIGH GEAR

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY
RETURN TO
ENGINE AERO
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 78010 M.C.J
1112/28

RELEASED
2011-10-03
mb

B	REVISED D3805-1F/3F TO EASE MANUFACTURABILITY (ADDED CUTOUT AT FWD END OF PLATE PER PAR11-108) AND RE-ORGANIZED NOTES SHEETS 2 & 3		MB	11.09.16
A	NEW ISSUE		MB	08.11.21
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE USA, INC.			
DRAWN	KENT, WA			
CHECKED	DRAWING NO. D3805		REV. B	
MFG. APPR.	SHEET 1 OF 8			
APPROVED	TITLE WEARPLATE ASSY		SCALE	
DE APPR.	NTS			
DATE	11.09.16			

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

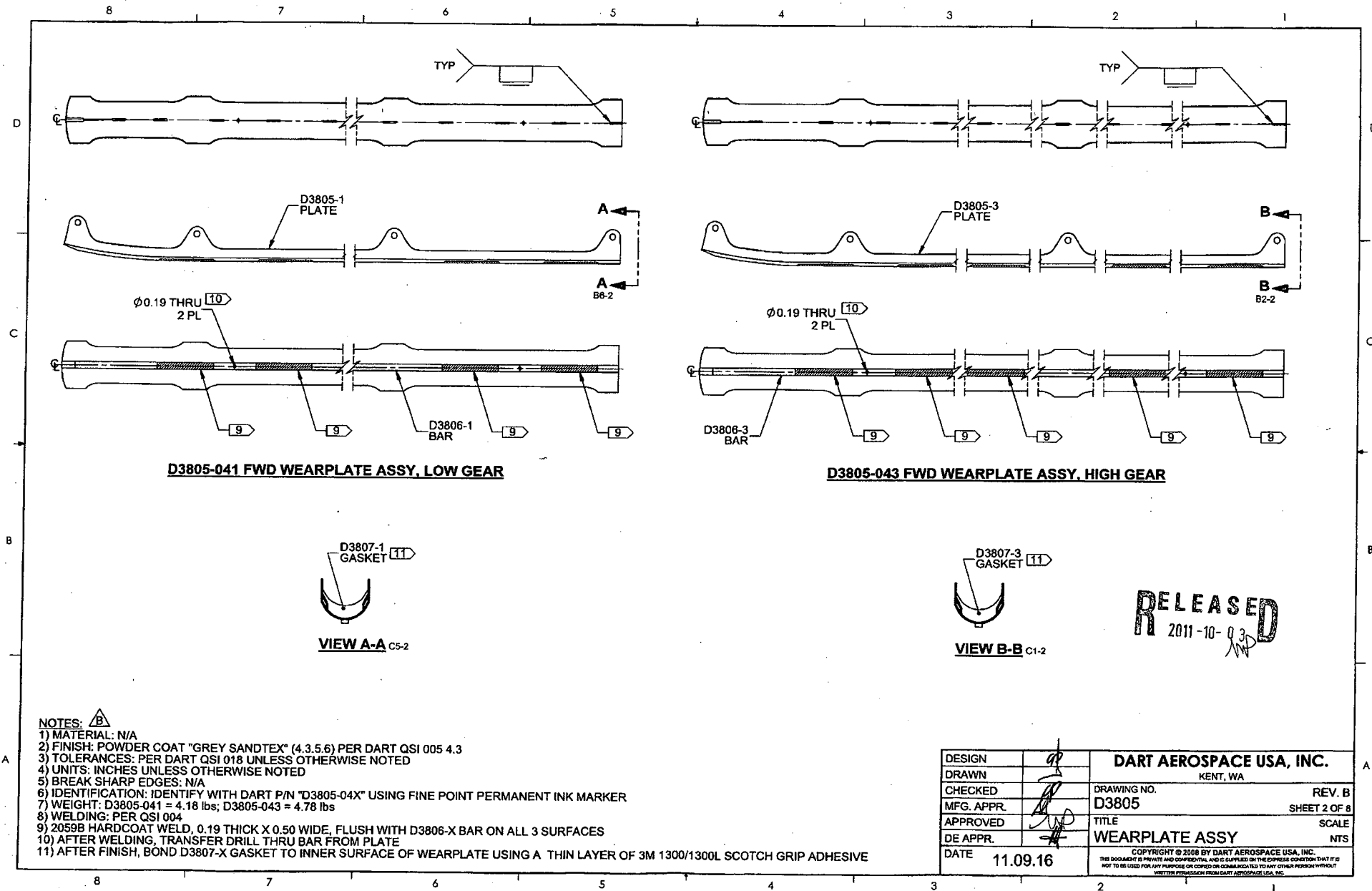
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78010



DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D3805	REV. B
MFG. APPR.		SHEET 2 OF 8	
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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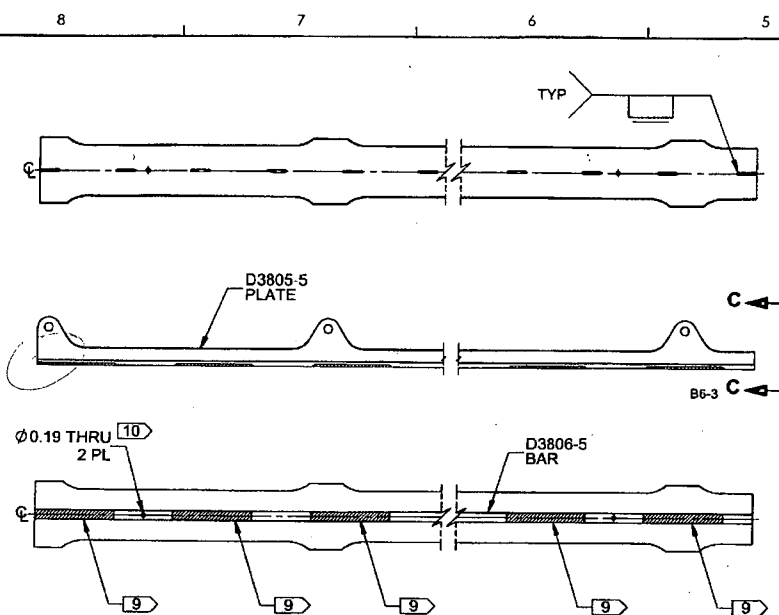
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

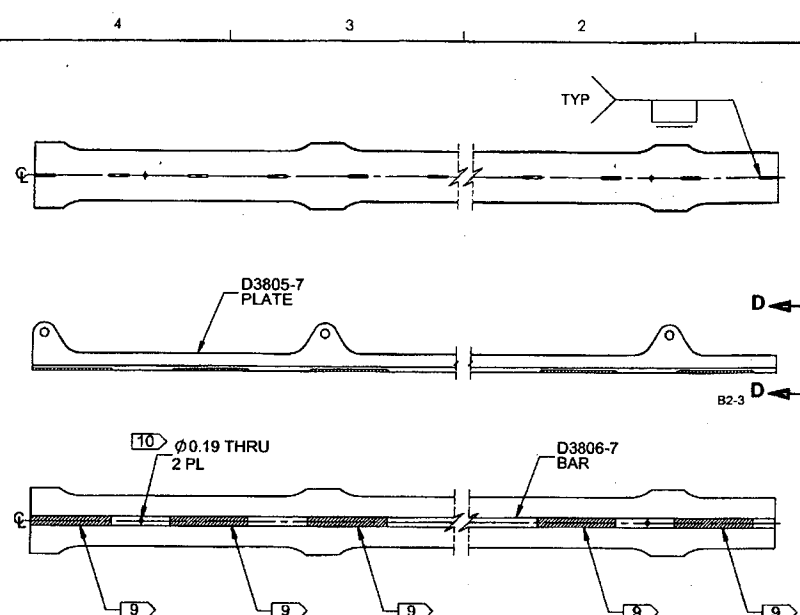
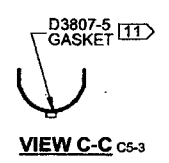
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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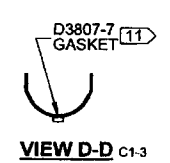
78010



D3805-045 AFT WEARPLATE ASSY.



D3805-047 AFT WEARPLATE ASSY.



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3805-045 = 4.24 lbs; D3805-047 = 4.53 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
 - 10) AFTER WELDING, TRANSFER DRILL THRU BAR FROM PLATE
 - 11) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	92	DART AEROSPACE USA, INC.	
DRAWN	92	KENT, WA	
CHECKED	92	DRAWING NO.	REV. B
MFG. APPR.	92	D3805	SHEET 3 OF 8
APPROVED	92	TITLE	SCALE
DE APPR.	92	WEARPLATE ASSY	NTS
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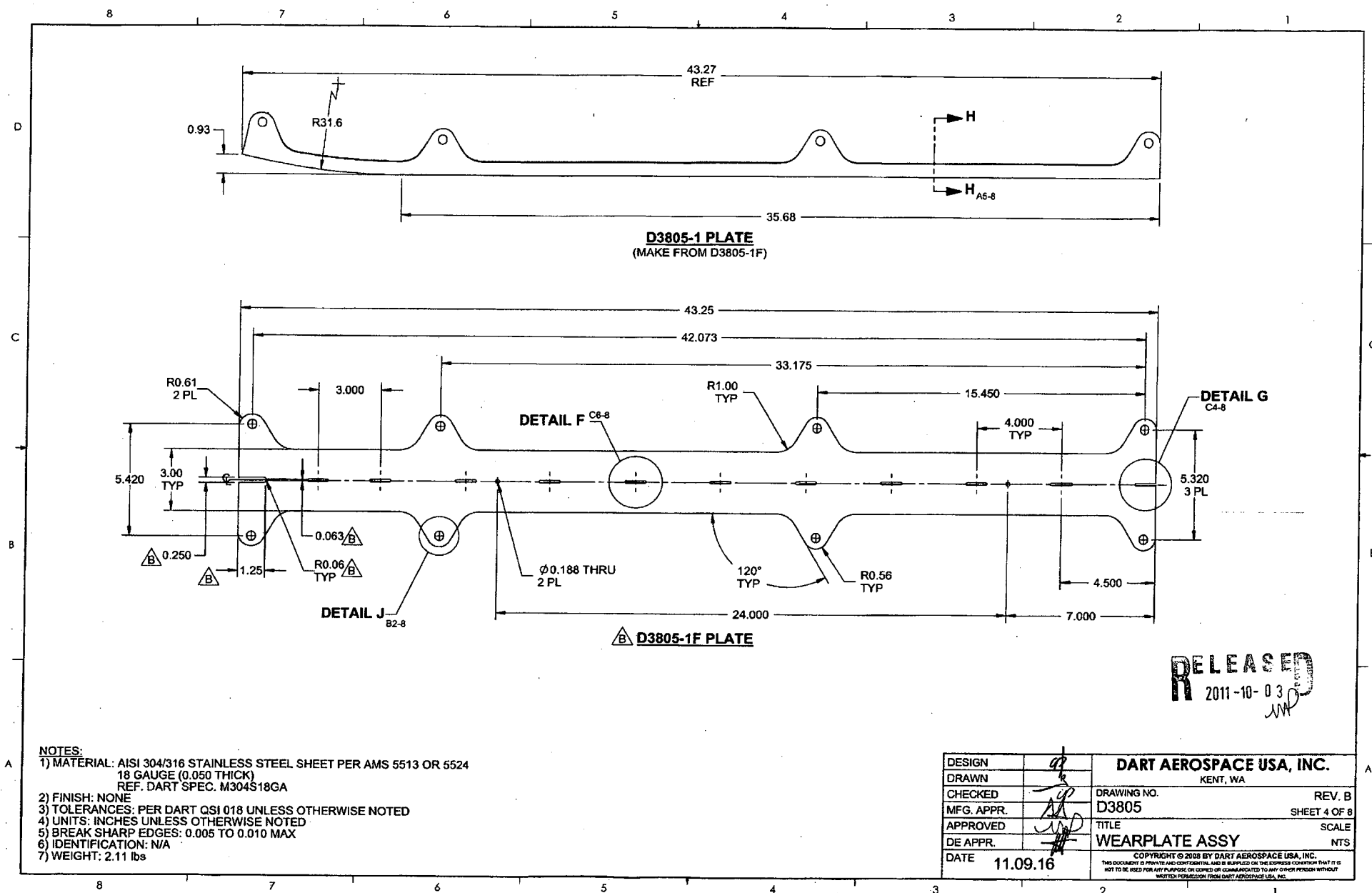
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78010



RELEASED
2011-10-03

DESIGN	42	DART AEROSPACE USA, INC.	
DRAWN	6	KENT, WA	
CHECKED	7	DRAWING NO.	REV. B
MFG. APPR.	11	D3805	SHEET 4 OF 8
APPROVED	11	TITLE	SCALE
DE APPR.	11	WEARPLATE ASSY	NTS
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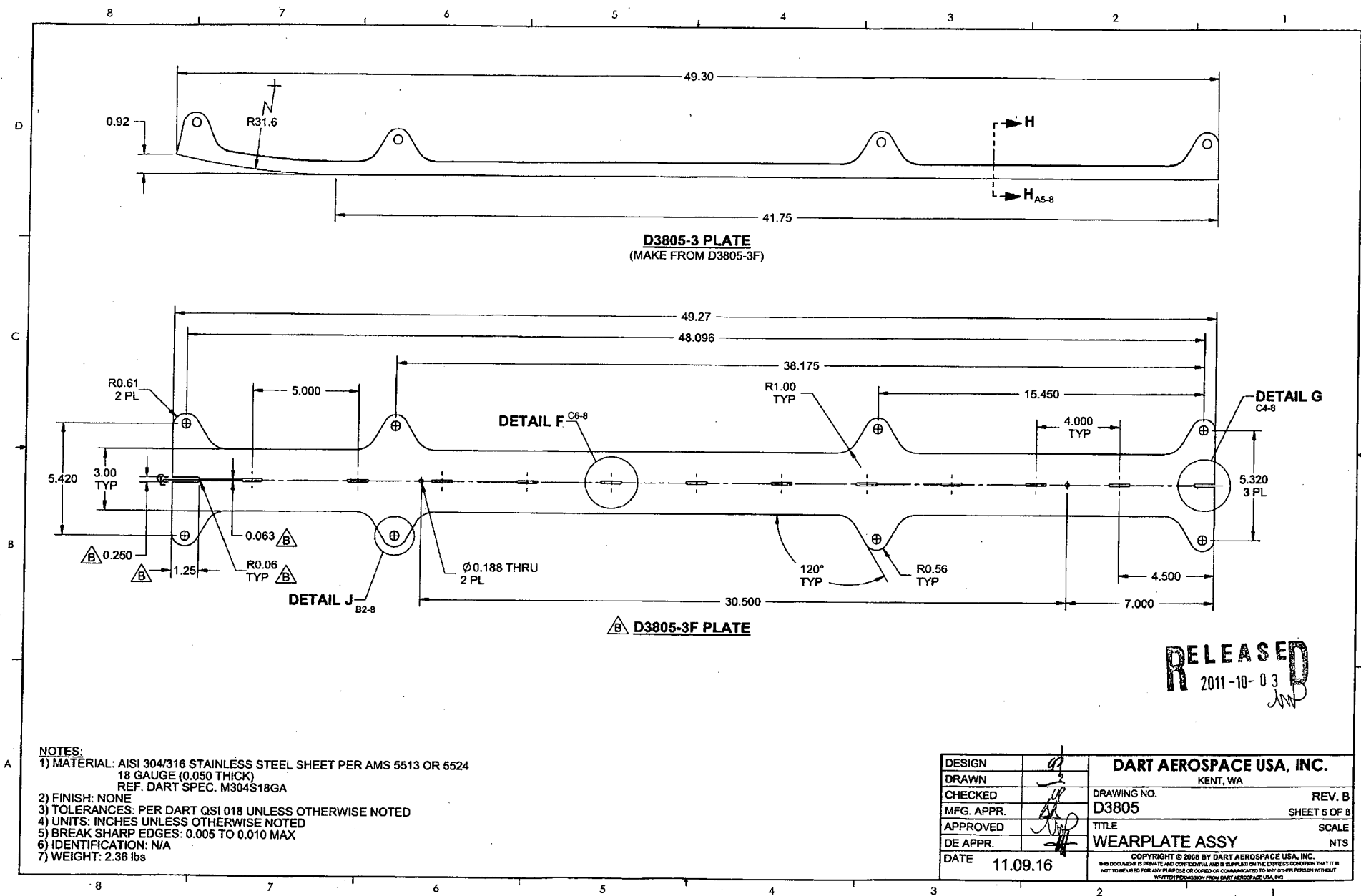
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78010



- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.36 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 5 OF 8
APPROVED		TITLE	SCALE
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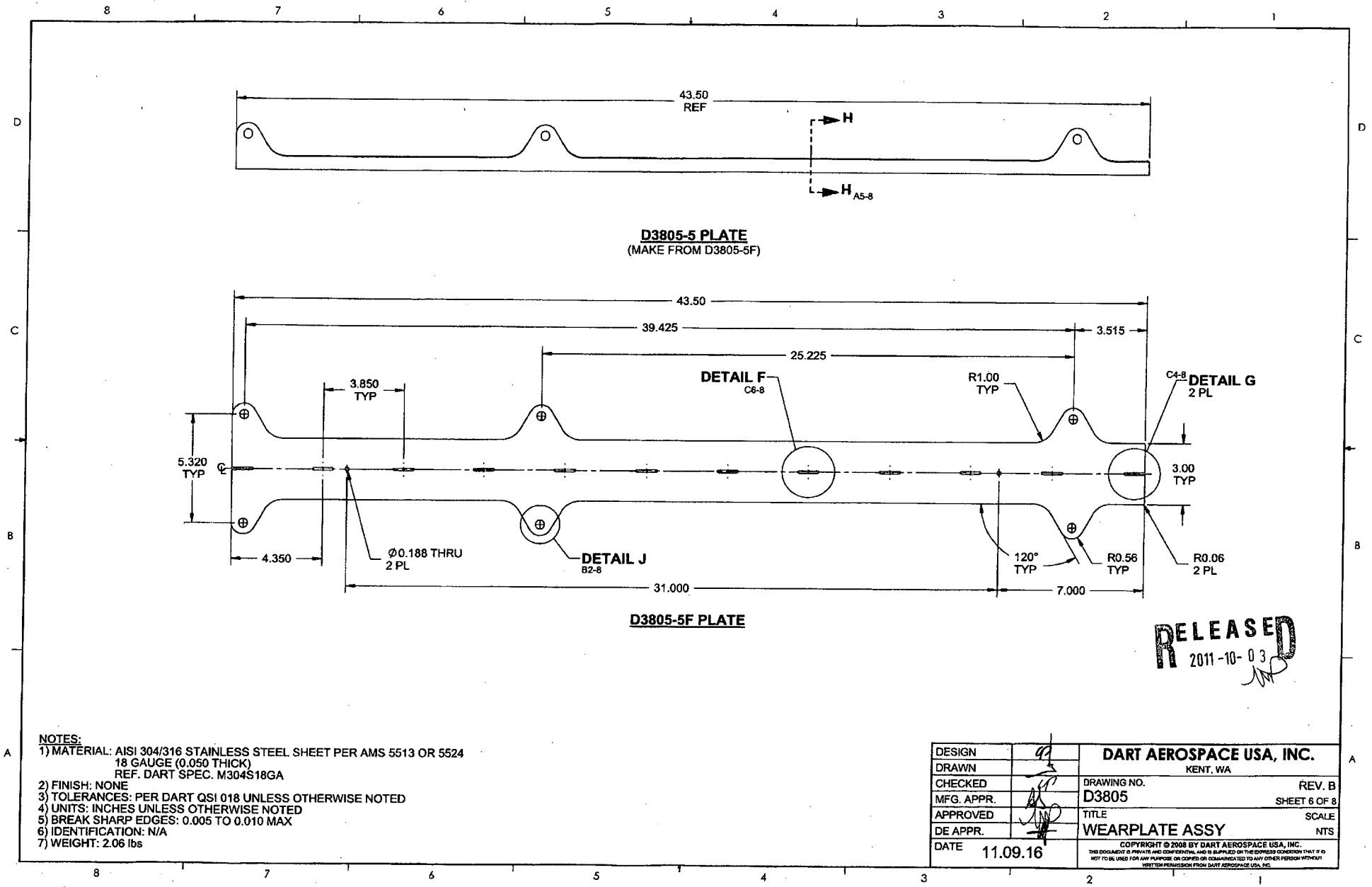
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78010



RELEASED
2011-10-03

- NOTES:
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.06 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 6 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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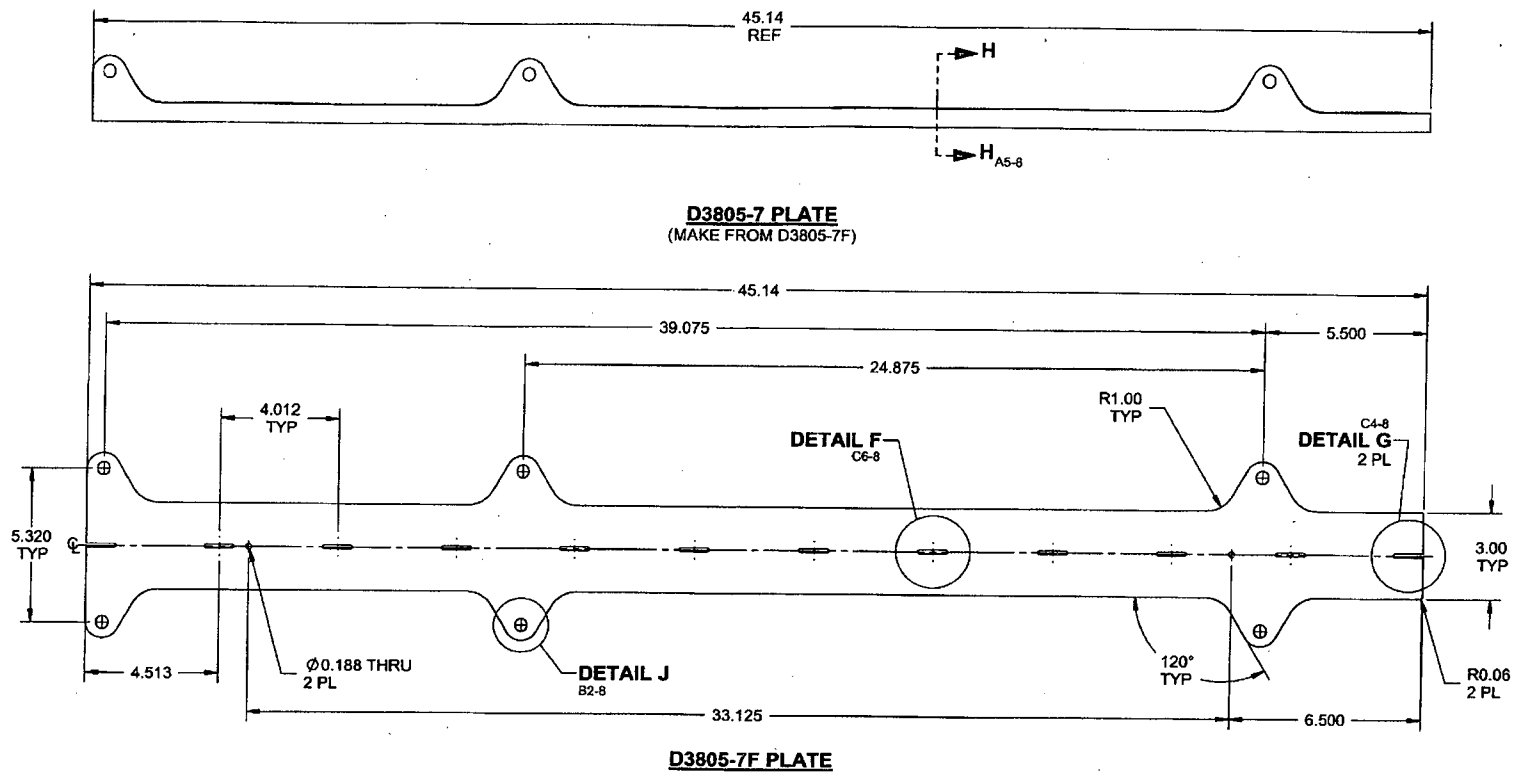
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RELEASED
2011-10-03

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
18 GAUGE (0.050 THICK)
REF. DART SPEC. M304S18GA
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
DATE	11.09.16	<small>COPYRIGHT © 2008 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES BEYOND OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

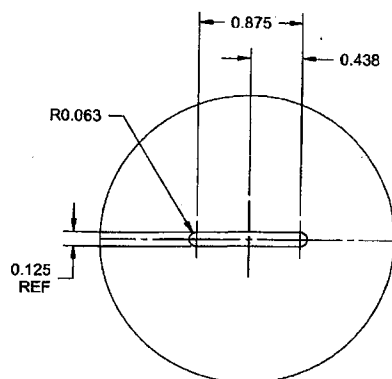
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

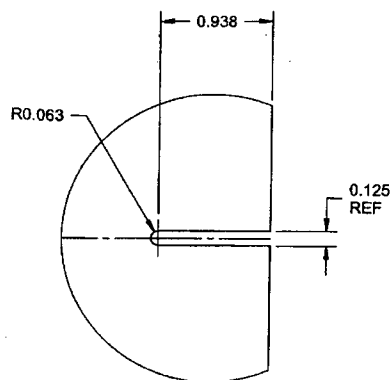
NOTE: Date & initial all entries

78010



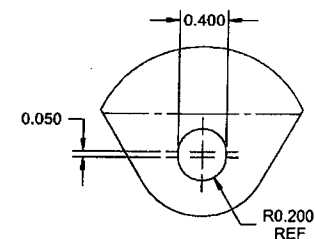
DETAIL F
SLOT DETAIL TYP
SCALE 4X

C5-4
C5-5
C4-6
C4-7



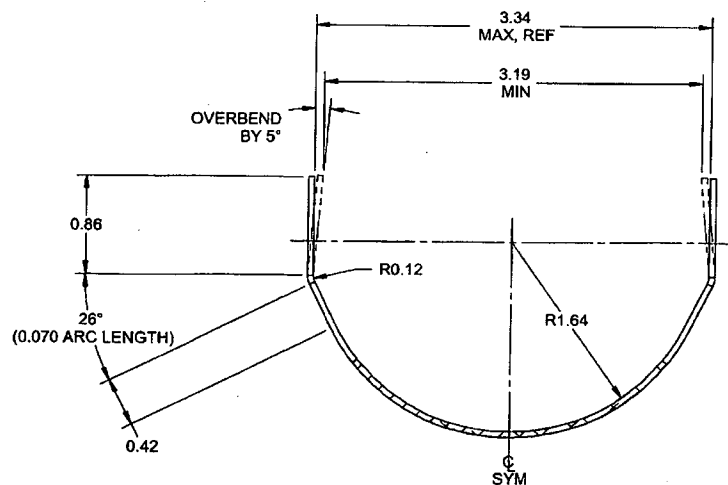
DETAIL G
SLOT DETAIL TYP
SCALE 4X

C1-4
C1-5
C1-6
C2-7



DETAIL J
SCALE 4X

B6-4
B7-5
B5-6
B5-7



SECTION H-H
SCALE 4X

D3-4
D3-5
D3-6
D3-7

RELEASED
2011-10-03
WTH

DESIGN	47	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3805	SHEET 8 OF 8
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries